Friday, 06/07/2007 1:36:25 PM Date: Linda Lacelle User: **Process Sheet** Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** : LITTER DECKPLATE 350 Job Number : 33262 **Estimate Number** : 10357 P.O. Number 414: Part Number : D2344 S.O. No. : NIA : D2344 REV F : 06/07/2007 **Drawing Number** This Issue : N/A Prsht Rev. **Project Number** : MACHINED PARTS Type First Issue **Drawing Revision** ·NIA Previous Run Material **Due Date** : 10/07/2007 Each Qty: Um: Written By Checked & Approved By Removed P/O for powder coat EC Comment : Est Rev:D 00.06.26 Asper Rev F JLM Est Rev:E 07-07-04 **Additional Product** Job Number: **Description:** Seq. #: **Machine Or Operation:** M2024T3S063 1.0 2024-T3 .063 sheet Comment: Qty.: 0.7823 sf(s)/Unit Total: 3.1290 sf(s)Material: 2024-T3 QQ-A-250/5) .063 Batch 1104921 FLOW WATER JET 2.0 3.0 QC2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE



4.0



SECOND CHECK

Comment: SECOND CHECK

5.0 _ SMALL FAB





Comment: SMALL/MED FAB

1-Deburr sharp edges

07.08.07

2-Countersink holes per Dwg D2344



Date:

Friday, 06/07/2007 1:36:25 PM

User:

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER DECKPLATE 350

Job Number: 33262

Part Number: D2344

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

Comment: HAND FINISHING RESOURCE #1



7.0

HAND FINISHING RESOURCE #1





POWDER COATING



Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

Chemical Conversion Coat as per QSI 005 4.1

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

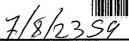


9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVE





10.0

PACKAGING 1

PACKAGING RESOURCE



11.0

Comment: Identify and Stock

Location:

QC21



Comment: FINAL INSPECTION/W/O RELEASE





Job Completion



N 7908-20

Friday, 6/29/2007 11:17:54 AM

Kim Johnston

Process Sheet

Drawing Name

Part Number

Drawing Number

Project Number

: CU-DAR001 Dart Helicopters Services Customer

Job Number : 33262

: 10357 **Estimate Number**

P.O. Number

: 6/29/2007

This Issue

: NC Prsht Rev.

: 11 First Issue

: 31918 Previous Run

Written By

Checked & Approved By

Comment

Type

S.O. No. :

: MACHINED PARTS

: Est Rev:D 00.06.26 Removed P/O for powder coat EC

Drawing Revision Material

Due Date

: 7/10/2007

: D2344

: N/A

:XF

Qty:

: LITTER DECKPLATE 350

· D2344 UNDER REVIEW

Each 4 Um:

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description: 2024-T3 .063 sheet

1.0 M2024T3S063



Comment: Qty.:

0.7823 sf(s)/Unit Total:

Material: 2024-T3 QQ-A-250/5) .063

Batch

2.0

WATER JET

FLOW WATER JET

3.1290 sf(s)

Comment: FLOW WATER JET

3.0

QC2

INSPECT PARTS AS



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL/MED FAB

1-Deburr sharp edges

2-Countersink holes per Dwg D2344

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



Page 1

Dart Aerospace Ltd

W/O:		WORK ORDER CHAN	IGES				· · · · · · · · · · · · · · · · · · ·
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		•					
Part No	:	PAR #: Fault Category:		No DQ		Date:	

NCR:		V	VORK ORD	ER NON-CONFORMANC	CE (NCR)			
		Description of NC	Corrective Action Section B			Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
		,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,						

NOTE: Date & initial all entries

Friday, 6/29/2007 11:17:54 AM Date: User: Kim Johnston **Process Sheet** Drawing Name: LITTER DECKPLATE 350 Customer: CU-DAR001 Dart Helicopters Services Job Number: 33262 Part Number: D2344 Job Number: Seq. #: Description: Machine Or Operation: HAND FINISHING1 7.0 HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 8.0 POWDER COATING Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION 9.0 Comment: INSPECT POWDER COAT/CHEMICAL ONVERSION PACKAGING RESOURCE #1 10.0 Comment: Identify and Stock Location: FINAL INSPECTION/W/O RELEASE 11.0 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGE	WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	PROCEDURE CHANGE	CHANGE By Date		Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
				,						
Part No	•	PAR #: Fault Category:	NCR: Yes	No DQA	۸:	Date:				

QA: N/C Closed: ____ Date: ___

NCR:			WORK ORDE	ER NON-CONFORMAN	CE (NCR)			
		Description of NC		Corrective Action Section B				
DATE	STEP	Section A	Initial Action Description Sign & Chief Eng Chief Eng Date		Verification Section C	Approval Chief Eng	Approval QC Inspector	
						:	i	
			•					
						-		

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: Litter Deck Plate Kit (350)	Part Number:	D2344
Inspection Dwg: D2344 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments
	0.991 🛴	+/-0.005						
	6.223	+/-0.010	6,222	1		Vern		
	5.598	+/-0.010	5,598	V		Vern		
	4.869	+/-0.010	4.868	V		Vera		
	3.889	+/-0.010	3.845			Vern		
	3.096	+/-0.010	3.101		"	Vern.		
	2.891	+/-0.010	2.899	V		Vern		
1	/ 16.973	+/-0.010	16.963	/		M-T/vers	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	
[]_0	0.966	+/-0.005						
	0.450	+/-0.010	0.457		,	Vern		
	4.423	+/-0.010	4,423			Vern		
	4.723	+/-0.010	4,722	1		Vern		
	1.202	+/-0.010	1,204			Vern		
	5.869	+/-0.010	5.870	V	-	Vern		
	4.654	+/-0.010	4.650			Vern		
	Ø0.656	+0.005/-0.000	\$0.657	/		Vern		
	1.888	+/-0.010	11,791			Vern		
	2.285	+/-0.010	2.290			Vern		
	2.683	+/-0.010	2.685	/		Vern		No. of London
1	Ø0.171	+0.005/-0.000	00,173			Vern		
	€ 0.750 ₹	A//A +/-0.005						
/"/	3.491	+/-0.010	3,494		<u> </u>	Vern		11 11 11
	Ø0.191	+0.005/-0.000	60.192			Vern		
1/1	-0.796 - 2	1/4 +/-0.005						
,	3.123	+/-0.010	3.127			Vern		
159	1527-3	1/4- +/-0.010				, , , ,		
	1.975	+/-0.010	1.980		,	Vern		(3)
	\$.128	4.605/	100.128	10		Vern		
/	Measured by:	SAI	Audited by:	50		Prototype App	roval:	N/A
	Date:	07/09/10A	Date:	12/0	0/10		Date:	N/A

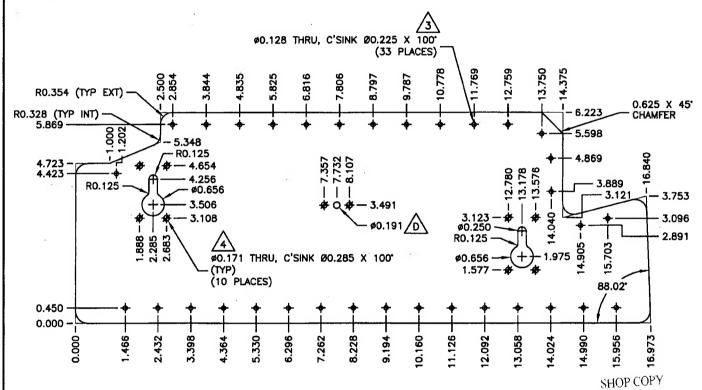
Date: 07/09/09 Date: 07/08/02 Date: N/A

Rev	Date	Change		Revised by	Appro	ox∮ed
Α	04.06.25	New Issue	P/O D350-616-015	KJ/JLM 🚓	5/1	7

#



DESIG:	N -	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECK	(ED)	APPROVED.	DRAWING NO. REV. F D2344 SHEET 1 OF 1
DATE	***************************************		TITLE SCALE
07.0	6.07		LITTER DECK PLATE, 350 1:3
Α		95.01.14	NEW ISSUE
В		95.02.09	MOVED KEY HOLES
D		95.03.06	0.191 WAS 0.197
E		98.06.19	0.063-0.071 THICK WAS 0.071 (TSR A371)
F		07.06.07	C'SINK Ø0.285 WAS Ø0.308



RETURN TO

ENGINEERING

D2344 LITTER DECK PLATE.

UNCONTROLLED COPY 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063-0.071 THICK PER QQ-A-250/SUBJECT TO AMENDMENT (REF. DART SPEC. M2024T3S)

2) FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3 WITHOUT NOTICE 3.3 COUNTERSINK HOLES MARKED \$ TO \$0.225 \times 100' WORK Or W

5) BREAK ALL SHARP EDGES 0.005 TO 0.010

6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

8) IDENTIFY WITH DART P/N "D2344" USING WHITE PAINT MARKER

NO. ____ RELEASED

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